

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001664**Date Inspected:** 01-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 530**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

This Quality Assurance Inspector (QAI) observed various fabrication and welding practices at Zhenhua Port Machinery Company (ZPMC) on Changxing Island in Shanghai, China today for the Self Anchored Suspension Bridge for San Francisco, California.

Orthotropic Box Girder (OBG)

This Quality Assurance Inspector (QAI) performed ultrasonic testing (UT) on the tack weld locations of the partial joint penetration (PJP) welds between the closed u-ribs and deck panel of DP015-001 for depth of penetration. The weld joints tested included welds 002 and 003. There was one tack weld location with less than 9.6 millimeters (80%) penetration on weld 002 and 15 locations on weld joint 003. See ultrasonic testing report TL-6027 Modified dated March 1, 2008 for details.

This QAI performed visual testing (VT) on deck panel DP017-001 PJP welds for conformance to the Special Provisions and Code. Weld joint examined were 001 & 006. This QAI was accompanied by two other QAI's who examined weld joints 002, 003, 004 & 005. Data was recorded on the Caltrans QA Visual Inspection Report for the OBG

Deck Panels spreadsheet.

WELDING INSPECTION REPORT

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QAI's performing visual testing on deck plates out in the yard



Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Hager, Craig

QA Reviewer